

Date: Wednesday, 7/4/2007 2:44:57 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT CAP		
Job Number	: 33288					
Estimate Number	: 10312					
P.O. Number	: N/A		Part Number	: D2646 <i>up</i>		
This Issue	: 7/4/2007	S.O. No. : N/A	Drawing Number	: D2646 REV C		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: C		
Previous Run	: 32427		Material	: N/A		
Written By			Due Date	: 7/17/2007 Qty: 20 Um: Each		
Checked & Approved By						
Comment	: Est: 05.08.22 Hole size revised in Step 5 KJ/JLM Est Rev:H Changed Inserts 07-02-19 JLM est rev I changed inserts 07.06.11 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING

Comment: PURCHASING

Issue P/O: 4101
 1-Spin as per Dwg D2646
 2-Material release note required

Cd 07/07/04
(20)

2.0	D2646P	Aft Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage
 Ensure Material Release Note is attached

6/17/18 *(20)*

4.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

En 07/07/14 *(20)* *caen 10*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

2-Open holes to .297 as per Dwg D2646.

ml 07/07/24 *(20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

3-Deburr

6.0 QC5

INSPECT WORK TO CURRENT STEP



mul07/07/30

Comment: INSPECT WORK TO CURRENT STEP

En 07/07/20 (20)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

INSERT

Batch:

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

stock update

7/18/01 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/08/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(2d)

Comment: FINAL INSPECTION/W/O RELEASE

7/7/07/01

Job Completion



JULY 07-08-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

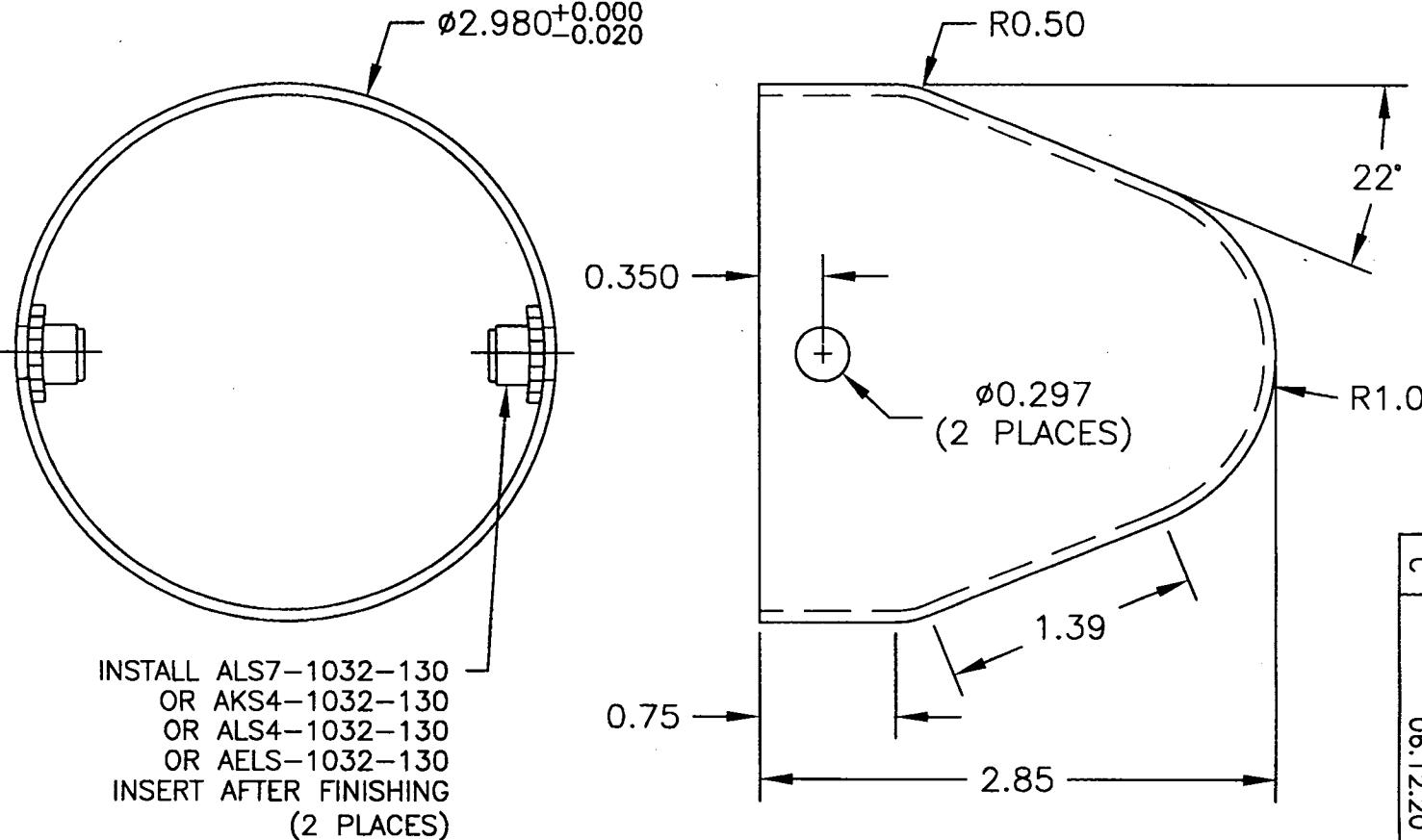
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
DS	RH	PORT HADLOCK, WA	REV. C
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
		D2646	SCALE
DATE	TITLE		
A 06.12.20	NEW ISSUE		
B 05.04.01	CHANGE TO CLOSED INSERTS		
C 06.12.20	CHANGE TO OPEN ENDED INSERTS		



RELEASED
07.02.12 RH

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3328



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, Langley, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: July 17

Customer: Dart Aerospace

Packing Slip: 31391

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
D2646 Rev C	50	.063100	N/A	✓	XK

Notes:

Material Certification Attached: Yes



Alcoa Mill Products

1680 Manchester Pike
Lancaster Pa 17601

Certification of Test Results

SOLD TO	COPPER & BRASS SALES INC 22315 WEST ELEVEN MILE ROAD SOUTHFIELD, MI 48034		
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SHIPTO	COPPER & BRASS SALES INC 6555 E. DAVIDSON DETROIT, MI 48212		
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CERT NO 0000630431
 DATE 2/12/2005
 SKID NO 350025
 SKID WGT 6,654
 PAGE 1 OF 1

ORDER NO	LB8335	PO NO	CB2548			MILL FINISH
ITEM NO	1	PART NO	050393-8			NON ANODIZE QUALITY
ALLOY	1100	TEMPER	O	FORM		OUT: STANDARD MILL FINISH
GAUGE	.06300	WIDTH	48.0000	LENGTH		IN: STANDARD MILL FINISH
						NOT EMBOSSED

LOT: 245473 COIL: A01 DROP: 04M0509

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
*U504111	0.14	0.52	0.13	0.01	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.2 KSI
 TAIL ULTIMATE STRENGTH 13.5 KSI
 HEAD YIELD STRENGTH (OFFSET = .2%) 5.2 KSI
 TAIL YIELD STRENGTH (OFFSET = .2%) 5.1 KSI
 HEAD ELONGATION (G.L. = 2 IN) 33.5 %
 TAIL ELONGATION (G.L. = 2 IN) 32 %

* AS REPORTED BY SUPPLIER
 MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
 ASME SB209 1100 O, AMS 4001H 1100 O,
 ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
 ** END OF CERTIFICATION **

Attn Qc Dept

Date	9-10-05
Cust.	Seig
W/O #	139277
Qty.	2036
Size	Special Instructions
Part #	Alloy Heat/Lot
These test reports are for material shipped on your PO # 139277	
From Copper & Brass Sales	
<i>Jeff Kready</i>	
Quality Representative	
Customer Part #	

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

JEFF KREADY, LAB SUPERVISOR

